Making Shot Filled Tool Handles

by dwr

I got some brass 360 alloy and aluminum to make my own shot filled tool handles for my Doug Thompson tools.

I cut the aluminum to 24" in length (can shorten later as needed). Then I cut a 2¾" length of brass 360 alloy bar. I insert the brass 360 into the center of my *antique* Raffin chuck… fits like a glove. From there I drill out the center for 2" to accept the tang of the DT Tool. I set the VFD control to 30 cycles and it drills nicely on the old gap bed lathe.

Reverse the brass into my Stronghold chuck to finish turning the rest of the brass insert and shoulder.

Brass 360 insert pressed into the aluminum and getting chamfers and bevels.

Mounted back into the Raffin chuck using inner diameter and live center. Here is the full length set-up of the handle in the lathe getting the bevels, etc., before sanding.

After finishing the end, I sand several grits to remove scale and give the tool a good finish. Here is the finished handle with the brass 360 insert, sanded and polished a bit and ready for a DT Tool. I'll add two set screws to the handle to hold the tool in place. I'll need to add a plug to the other end after deciding on and cutting to final length. The plug will have a threaded insert to add and remove shot for weight and dampening.

A DT ⅜" detail gouge installed (sorry about the picture quality. I loaned all my larger bits out and have to wait to drill out the insert to ½" for the larger gouge.

I am making four handles for ½" and ⅝" diameter shanks. A little work and I have aluminum shot filled handles for less than one fifth the price of commercial handles. I will also be making smaller handles for the ⅜" DT Tools and for some mini-hollowing tools.